Dart Aerospace Ltd. Thursday, 12/20/2007 3:20:03 PM Kim Johnston **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : SPACER BUSHING Customer Job Number **Estimate Number** : 10826 : D23273 Part Number P.O. Number D2327 REV D : 12/20/2007 S.O. No. : **Drawing Number** This Issue : N/A : NC Prsht Rev. Project Number : D First Issue : // Type : MACHINED PARTS **Drawing Revision** : 34589 **Material** Previous Run **Due Date** : 1/20/2008 Qtv: 50 Um: Written By Checked & Approved By : Est. F 0\$ 11.02 Removed 303 SS KJ/EC Comment **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 304 SS ROUND BAR M304R0375 Comment: Qty.: 0.1641 f(s)/Unit Total: 8.2058 f(s) Inventory Material: AISI 304 Round Bar Ø0.375" (M304R0.375) HARDINGE 2.0 Comment: HARDINGE CNC LATHE SMALL Turn per Folio FA232 and Dwg D2327 Deburr QC2. INSPECT PARTS AS THEY COME OFF MACHINE 3.0

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0 PACKAGING 1

4.0

PACKAGING RESOURCE #1

Each

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

Dart Aerospace	Ltd	
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Dart Ae	rospace Lt	d -								
W/O:		WORK ORDER CHANGES								
DATE	STEP	PI	ROCEDURE CHANGE =	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	·	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	_ Date: _			
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NCR:	-		WORK ORDER NON-CON	ORMANCE (NC	R)					

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
	×4.	Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector
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NOTE: Date & initial all entries

Date:

Thursday, 12/20/2007 3:20:03 PM Kim Johnston

User:

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 36479

Part Number: D23273

Job Number:

Seq. #:

Job Completion

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



NAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE



# Dart Aerospace Ltd

W/O:			WORK ORDE	WORK ORDER CHANGES					
DATE	STEP	0	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Part No			PAR #: Fault Category:	NC	R: Yes	No DQ	A:	Date:	
					QA:	N/C Close	d:	_ Date: _	

	WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC	Corrective Action Section B			Varification	A	Approval	
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36479
Description: Spacer Bushing	Part Number:	D2327-3
Inspection Dwg: D2327 Rev: D		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
Ø0.375	±0.005/-0.000	ø.3744	<b>√</b>				
Ø0.257	+0.005/-0.000	Ø .259	/		110.00		
1.750	+/-0.010	1.750	~				
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Measured by:	H.A/Ind	Audited by:	Prototype Approval:	N/A
Date:	08/01/19	Date: 08/01/19	Date:	N/A

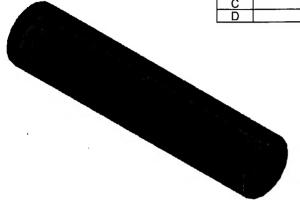
Rev	Date	Change	Revised by	Approved
Α	04.01.13	New Issue	KJ/RF	
В	06.11.24	Dwg Revision revised	KJ/JLM OK	Æ

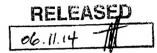


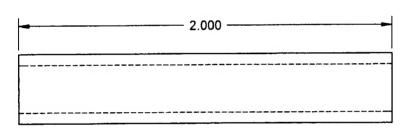


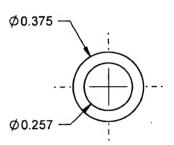
DESIGN	DRAWN BY	DART AEROSPA	CE LTD
BW	$\subset \mathcal{B}$	HAWKESBURY, ONTARIO	_
CHECKED	APPROVED:	DRAWING NO.	REV. D
15	g#	D2327	SHEET 1 OF 1
DATE	· · · · · · · · · · · · · · · · · · ·	TITLE	SCALE
-06 1	IN 12	SPACER BUSHING	2.4

	00.10.1=		
REV	DATE	DESCRIPTION	
Α	94.12.17	NEW ISSUE	
В	95.12.06	LENGTH CHANGE	
С	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	



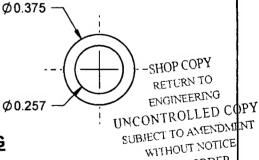






### **D2327-1 SPACER BUSHING**

- 1.750 **-**



# **D2327-3 SPACER BUSHING**

NOTES: 1) MATERIAL: AISI 304/316 SS,  $\phi$  0.375, 0.065 WALL SEAMLESS ROUND TUBING NATIONAL SEAMLESS ROUND TUBING 375W 065) (REF. DART SPEC M304TR0.375W.065)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



WORK ORDER

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